

GENERAL INSTRUCTIONS FOR WORKING WITH GLASSFIBRE

1. Work in dry, well-drained and warm conditions. Dampness and cold inhibit cure.
2. Protect yourself and your clothes. Wear gloves. Wear a fume mask if working in enclosed spaces. Protect your eyes from contact with resin, catalyst and acetone.
3. Thoroughly prepare surface to be worked on, removing all traces of oil, dirt, water etc. For repairs to existing GRP ensure a good key is obtained by aggressive sanding with coarse grit sandpaper.
4. Have everything ready before starting work:
Cut glass mat to size. Pour the required amount of resin into a container. Have a jar of acetone ready to clean the brushes and rollers after use.
5. Add hardener to the resin accurately and carefully – too much will prevent cure, too little will retard it. As a rule of thumb 20cc of hardener to 1 kilogram of resin should be used, giving a pot life of about 20 minutes at 20 deg C. In warm weather reduce this to no less than 10cc per kilo and in cold weather increase to no more than 30cc per kilo. Only catalyse as much resin as can be used within the pot life.
The lids of the hardener bottles hold approximately the following amounts:
100cc bottle – 3cc; 250cc bottle – 4cc; 500cc & 1 litre bottle – 5cc.
Mix the hardener thoroughly into the resin before use.
6. Using a brush or mohair roller, apply the resin evenly over the surface to be fibreglassed. Lay down the glass mat and apply more resin, spreading out liberally and evenly over the mat. Using a paddle roller, or stippling with a brush, thoroughly “wet-out” the glassfibre, so that the glass is fully impregnated with resin and all air bubbles removed.
7. Wash out brushes and rollers thoroughly in acetone after use. To save for re-use follow this by washing in warm soapy water and allow to dry.

Further Notes

Gelcoat: is the hard glossy external finish on a GRP product. When applied to the prepared mould, the surface exposed to the air dries with tackiness so that a good bond is achieved with subsequent laminates.

Flowcoat: is similar to gelcoat in consistency, but has a wax additive which prevents tackiness. It is used as a finishing coat on raw laminates and repairs etc. It can be bought pre-mixed or can be made by adding wax solution to a resin-gelcoat mixture. (Approximately 40cc per kilo) Non-slip flowcoat is also available.

Coverage for both materials ranges from 0.5 – 1kg per m², depending on consistency and surface detail. As both gelcoat and flowcoat are polyester resins, catalyst must be added as outlined in (5) to effect cure.

HEALTH AND SAFETY:

Please refer to the labels on the resin, catalyst and acetone containers and note the hazardous nature of the products and the safety precautions to be taken when using them. For further information refer to the relevant MSDS (Material Safety Data Sheets) - available on request.

KEEP ALL MATERIALS OUT OF THE REACH OF CHILDREN

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